

5/30

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23815</b>
<b>Description: Inner Aft Saddle</b>	<b>Part Number:</b>	<b>D5957</b>
<b>Drawing: D5957 Rev. A</b>	<b>Qty:</b>	<b>12</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required</i>	<i>PH</i>	05.07.14	12
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <i>B21802</i> <i>B23250</i>	<i>PH</i>	05.10.14	12
3	HAAS	Setup W/O No. <i>/</i> Setup Inspection last completed <i>/</i> by <i>/</i>	<i>/</i>	N/A	<i>/</i>
4	HAAS	Machine as per folio D5957 <b>Ensure Batch Number is entered</b>	<i>M.L.</i> <i>J.L.</i>	05.08.09	12
5	HAAS	Deburr and Tumble	<i>J.L.</i>	05.08.09	12
6	QC	Inspect Level 1 Fill Out Inspection Sheet	<i>J.L.</i> <i>M.L.</i>	05.08.09	12
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>E</i>	05.10.09	12
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>MM</i>	05.08.17	12
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>MM</i>	05.08.17	12
10	QC	Inspect Level 3	<i>DL</i>	05.10.20	12
11	STORES	Pack in foam, identify and stock	<i>DL</i>	05.10.20	12
12	EXPEDITING	Close Work Order <i>143.83</i> Cost / Part: <i>143.99</i>	<i>AR</i> <i>PH</i>	05.10.24 05.10.25	12 12

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06 *PH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 05/08/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23815
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	—	—	—	—		
B	1.745	1.755		1.749	1.750	1.750	1.749		
C	5.245	5.255		5.248	5.250	5.250	5.250		
D	6.995	7.005		6.998	6.998	6.999	6.998		
E	5.745	5.755		5.748	5.748	5.748	5.749		
F	4.745	4.755		4.748	4.748	4.748	4.749		
G	0.313	0.318	DT8686	—	—	—	—		
H	1.522	1.532		1.527	1.526	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.579	4.580		
K	0.313	0.318	DT8686	—	—	—	—		
L	0.240	0.260		0.253	0.252	0.255	0.255		
M	0.490	0.510		0.501	0.501	0.501	0.501		
N	0.240	0.260		0.253	0.252	0.255	0.254		
O	7.990	8.010		7.998	7.999	8.000	8.001		
P	0.240	0.260		0.253	0.254	0.253	0.253		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.502	0.503	0.503	0.503		
T	1.625	1.645		1.634	1.633	1.633	1.634		
U	2.000	2.020	DT8696 A/B	—	—	—	—		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	M.L./J.L.
Date:	05.08.9

Audited by:	SD
Date:	05.08.05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

RELEASED  
03.06.18

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23815</b>
<b>Description:</b> Inner Aft Saddle	<b>Part Number:</b>	<b>D5957</b>
<b>Inspection Dwg:</b> D5957 Rev. A		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	5.245	5.255		5.250	5.249	5.249	5.250		
D	6.995	7.005		6.998	6.998	6.998	6.998		
E	5.745	5.755		5.748	5.749	5.749	5.750		
F	4.745	4.755		4.750	4.749	4.749	4.749		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		-254	-253	-254	-255		
M	0.490	0.510		.501	.502	.500	.501		
N	0.240	0.260		-254	-255	-255	-255		
O	7.990	8.010		8.000	8.000	8.001	8.000		
P	0.240	0.260		-253	-251	-251	-250		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.501	.501	.501	.501		
T	1.625	1.645		1.634	1.636	1.635	1.634		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓					

Measured by:	J.L
Date:	05.08.09

Audited by:	SD
Date:	05.08.09

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

**RELEASED**  
03.06.18

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23815</b>
<b>Description:</b> Inner Aft Saddle	<b>Part Number:</b>	<b>D5957</b>
<b>Inspection Dwg:</b> D5957 Rev. A		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
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B	1.745	1.755		1.749	1.749	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.249	5.249		
D	6.995	7.005		6.998	6.999	6.998	7.000		
E	5.745	5.755		5.749	5.750	5.749	5.750		
F	4.745	4.755		4.749	4.749	4.750	4.780		
G	0.313	0.318	DT8686	/	/	/	/		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580			
K	0.313	0.318	DT8686	/	/	/	/		
L	0.240	0.260		-255	-255	-254	-254		
M	0.490	0.510		-503	-503	-502	-502		
N	0.240	0.260		-255	-254	-255	-254		
O	7.990	8.010		8.001	8.001	8.000	8.000		
P	0.240	0.260		<del>255</del> 252	-252	-252	-252		
Q	0.307	0.312		-311	-311	-311	-311		
R	0.760	0.765		-760	-760	-760	-760		
S	0.490	0.510		-501	-502	-501	-501		
T	1.625	1.645		1.639	1.634	1.634	1.634		
U	2.000	2.020	DT8696 A/B	/	/	/	/		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

SD

Measured by:	J.L
Date:	05.08.09

Audited by:	SD
Date:	05.08.09

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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RELEASED  
03.06.18

SD

SD

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 14, 2005  
01:41 pm

Work Order No : 0023815  
Project Name : D5957  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D5957  
Description : Saddle  
Manufactured : Yes  
Amount Req'd : 12  
Amount Done : 0  
Start Date : 07-14-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00